



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2432

Job Sheet 179676



Part No: D2432

Job Qty: 12 ea

Part Name: Bearpaw 19" X 24"



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea		7/18/18	0.00	0.00	Start Up Container		18/07/01
120	Waterjet	16 pcs		7/18/18	0.00	4.12	Waterjet 2 OMAX		18/07/01
130	CNC Vertical Machining	16 pcs		7/18/18	0.36	20.54	HAAS 1		18/08/19
140	QC	16 pcs		7/18/18	0.00	0.00	QC2		18/08/19
150	QC	16 pcs		7/18/18	0.00	0.00	QC8		18/08/19
160	Packaging	16 pcs		7/18/18	0.00	0.00	Packaging3		18/08/19
170	QC21-SA	16 Ea		7/18/18	0.00	0.00	QC21		18/08/19

Part Op 120 - Cut Blank as per D2432 File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Debur

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	59.2000 sf (3.7 ea)	90-Start up Operation	5045596

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	59	1,376	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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DART AEROSPACE LTD		Work Order: 179676
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Ver	
B	0.200	+/-0.030	.190	✓		D.G.	
C	0.25 x 45°	+/-0.030	0.25 x 45°	U		Ver	
D	R0.250	+/-0.030	R.0.250	✓		R.G.	
E	0.250	+/-0.010	0.255	✓		Ver	
F	0.625	+/-0.030	0.630	U		Ver	
G	0.375	+0.030/-0.010	0.387	✓		Ver	
H	0.950	+/-0.030	0.955	U		Ver	
I	19.000	+/-0.030	19.000	✓		TAPE	
J	Ø0.260	+0.005/-0.000	Ø.262	✓		G.V.P.	
K	Ø0.93	+/-0.030	Ø.931	✓		Ver	
L	0.30	+0.030/-0.000	.310	✓		D.G.	
M	23.750	+/-0.030	23.750	✓		TAPE	
N	2.000	+/-0.030	2.000	U		Ver	
O	0.38	+/-0.030	0.38	✓		Ver	
P							
Q							
R							
S							
T							
U							
V							

Measured by: DAS 52 9-89	Audited by:	Preliminary Approval:
Date: 18/08/19	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	

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